



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6005G01831-3G-PO

Job Sheet 191286



Part No: RBW6005G01831-3G-PO **Job Qty:** 3 pcs

Part Name: Dial Indicator Tail Rotor Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/19

Job Tracking No:

Due Date: 4/29/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6005G01831-3G Rev.3 IPP Rev. A 19.02.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	3 pcs	4/29/19	0.00	0.00	0.00	Purchasing - 1	DP APR 22 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	3 pcs	4/29/19	0.00	0.00	0.00	Packaging 2 - 1 - B4B	DP APR 22 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
120	QC 6	3 pcs	4/29/19	0.00	0.00	0.00	QC 6 - 42	DAS APR 22 2019 68
							QC 6 - 9	
							QC 6 - 68	
130	Packaging 3-1 - Stock - B4B	3 pcs	4/29/19	0.00	0.00	0.00	Packaging 3 - 1 - B4B	DA 20 9-89
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
140	QC 21 - SA	3 pcs	4/29/19	0.00	0.00	0.00	QC 21 - SA - 21	DAG 21 9-89 APR 30 2019
							QC 21 - SA - 70	

Part Op 100 - Issue P/O to ARROW TECH MACHINE WORKS ; P/O 042715 - Manufacture RBW6005G01831-3G as
Descriptions: per DWG. -Certificate of Conformity is required
110 - Certificate of Conformity is required

x3 Hums

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6005G01831-3Gp	Dial Indicator Tail Rotor Support	3 pcs (1 ea)	100-Purchasing	5173959

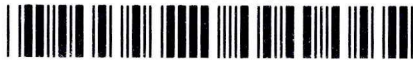
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6005G01831-3Gp	3	0	0

Part Specifications

Specifications could not be found.

Plex 2/26/19 11:14 AM dart.Lussier.Patrick

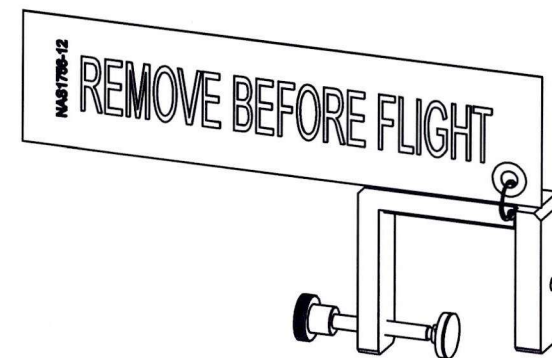
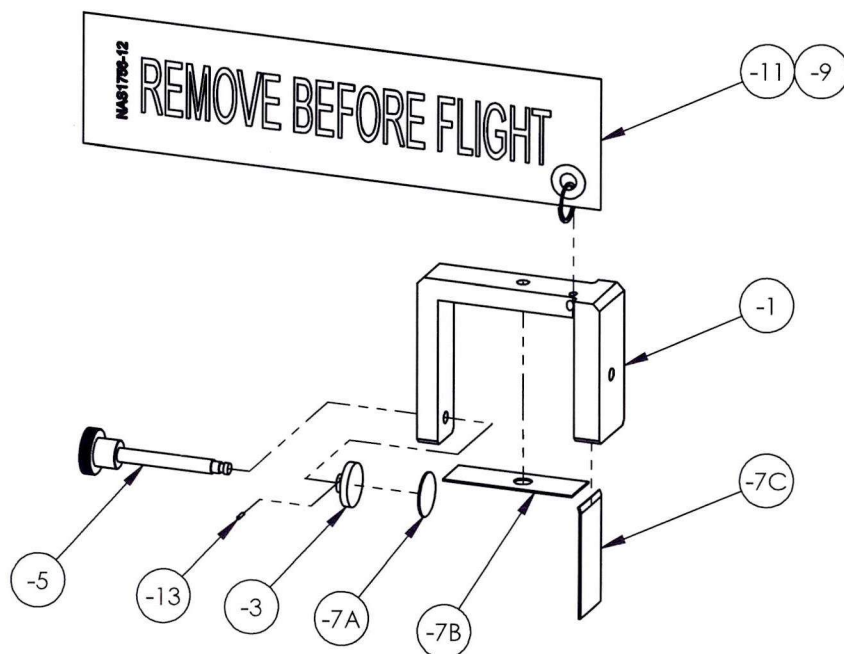
**Container No: S173962****Part: RBW6005G01831 - 3G****Job No: 191286****Serial No/Batch: S173962****Revision: 3****Inspector:****Exp Date:****Instructions:**

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/22/19

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REPLACED THUMB NUT, ALL THREAD & DOWEL PIN WITH THUMB SCREW & ROLL PIN.	3/20/2009	WP	DW
1A		CH'D ENGRAVE NOTE P/N -1.	5/28/2009	RJC	RW
2		CORRECTED DIM P/N -1 FROM .513 TO .482 DIM SNAPPED TO DIM EXT. NOT CORNER, CH'D P/N -11 FROM MAS1756-18, CH'D P/N -1 RADIUS FROM .250, ADDED MISSING R.125 DIM P/N -1 TOP VIEW, & .119 DIM SIDE VIEW.	10/14/2009	RJC	RW
2A		CH'D TITLE WAS SUPPORT, DIAL INDICATOR TAIL ROTOR ASSEMBLY IS SUPPORT ASSY, DIAL GAUGE (T/R DAMPER BLADE SIDE). -13 ADDED B/O P/N INFO. -1, -3, -5 MOVED TO SEPARATE SHEETS. -3 CH'D DIM WAS Ø.062 IS LIMITS Ø.062 TO .065.	4/15/2014	DPD	JAG
3	16-0224	UPDATED TO NEW STANDARD. -1 CH'D DIMS WAS .592 IS 2X .592. WAS 2X R.125 IS 2X R.13. WAS .188 IS .19. WAS .200 IS .20. WAS Ø.159 IS Ø.16. WAS R.312 IS R.31. WAS 2X R.030 IS 2X R.03. ADDED DIM 2.66. -3 CH'D DIMS WAS Ø.980 IS Ø.98. WAS Ø.393 IS Ø.39. WAS Ø.062-.065 IS Ø.062-.065 (P.F. -13). -5 CH'D DIMS WAS 3.31 IS (3.31). WAS 3.06 IS (3.06). WAS Ø1.00 MED KNURL IS (Ø1.00). WAS .625 IS (Ø.625). WAS 5/16-18 UNC IS (5/16-18 UNC). -7 DELETED FROM BOM. -7A, -7B, -7C ADDED TO BOM & DRAWING. -13 CH'D B/O REF WAS #90145A416 IS #92373A106.	11/17/2016	DPD	JAG



NOTES:

1. REFERENCE:

RBW6005G01831 = 3G6005G01831
 RBW6005G01831-1 = 3G6005G04131
 RBW6005G01831-11 = 999-3900-17-3

2. FUNCTION:

USED TO INSPECT FOR PLAY (AXIAL) OF THE T/R SPHERICAL BEARINGS (T/R BLADE SIDE), WITHOUT REMOVING THE COMPONENTS FROM THE AIRCRAFT.

DART AEROSPACE			
TITLE SUPPORT ASSY, DIAL GAUGE (T/R DAMPER BLADE SIDE)			
DWG NO. RBW6005G01831-3G			REV 3
MATERIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH		.XX ± .01 ANGLES ± 5°	
SPEC		.X ± .1 SURFACES = 125/	
DRAWN BY: PERRITT		1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		AW139	
SCALE 1:4	DATE 1/30/2009	SHEET 1 OF 7	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	CLAMP FRAME	304 S.S.		2
			-3	1	SWIVEL END	304 S.S.		3
			-5	1	THUMB SCREW	S.S.	5/16-18 X 3, Ø1 (MCMaster-CARR #6091K47) MODIFIED	4
			-7A	1	PAD MATERIAL WITH ADHESIVE BACK	NEOPRENE	.036 THICK, DUROMETER 60A (GASKET SPECIALTIES) MODIFIED	5
			-7B	1	PAD MATERIAL WITH ADHESIVE BACK	NEOPRENE	.036 THICK, DUROMETER 60A (GASKET SPECIALTIES) MODIFIED	6
			-7C	1	PAD MATERIAL WITH ADHESIVE BACK	NEOPRENE	.036 THICK, DUROMETER 60A (GASKET SPECIALTIES) MODIFIED	7
		B/O	-9	1	SPLIT RING	STEEL	Ø7/8 O.D. X 1/8 (MCMaster-CARR #90177A217)	1
		B/O	-11	1	REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	1
		B/O	-13	1	ROLL PIN	S.S.	Ø1/16 X 5/16 (MCMaster-CARR #92373A106)	1



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PURCHASE ORDER

PO042715



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO042715
PO Date: 2/26/19
Due Date: 4/29/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick

Ship To:

Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	191266	RBW0805G00332-3Gp			Jacking Bracket, Helicopter Weighing REV 2	Firmed	-	4/29/19	3 pcs	0 pcs	3 pcs	\$788.75/pcs	\$2,366.25
								3x MAR 26 2019					
2		RBW6005G01431-3Gp			Dial Indicator Main Rotor Damper Support REV 1A	Firmed	-	4/29/19	2 pcs	0 pcs	2 pcs	\$1,050.00/pcs	\$2,100.00
								2x MAR 29 2019					
3	191286	RBW6005G01831-3Gp			Dial Indicator Tail Rotor Support REV 3	Firmed	-	4/29/19	3 pcs	0 pcs	3 pcs	\$1,141.25/pcs	\$3,423.75
								X3 APR 22 2019					
4	191287	RBW6205G00432-3Gp			Main Rotor Pitch Control Link Adjustment Tool REV 5	Firmed	-	4/29/19	3 pcs	0 pcs	3 pcs	\$2,030.50/pcs	\$6,091.50
								3x APR 01 2019					
Grand Total:												\$13,981.50	



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PURCHASE ORDER

PO042715



Order Notes

Procurement Quality Clauses

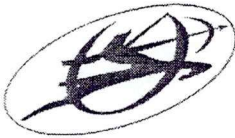
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/26/19 11:48 AM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 519

Date: 4/18/2019
PO Ref: 042715
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty

3

Item

SUPP ASSY, DIAL GUAGE (T/R DAMPER
BLADE SIDE)

Part No.

RBW6005G01831-3G

Received by:

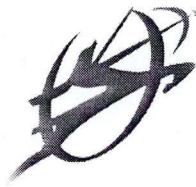
Packaged by:

J.M.L

Checked by:

AJP

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 042715

Dated: 4/18/2019

Our Order / Job No: 042715-3AWT

Order Qty: 3

Part Name: SUPPORT ASSY., DIAL GUAGE (T/R DAMPER BLADE SIDE)

Part Number RBW6005G01831-3G

Lot Size: N/A Ship Date: 4/18/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6005G01831-3G

Rev: 3

Material Size and Type: -1, -3/ 304S.S.

Material Specifications: S.S.: ASTM A511

Heat Treatment: N/A

Plating/Finish: N/A

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 4/18/19

Signed: Herman Falt

PHGE Machine Works LLC dba Arrow Tech Machine Works
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www.atechmachineworks.com